

Date: Monday, 11/6/2006 2:41:12 PM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLUG
Job Number : 29364
Estimate Number : 12337
P.O. Number : N/A Part Number : D3492043
This Issue : 11/6/2006 S.O. No. : N/A Drawing Number : D3492 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 29045 Material : N/A Due Date : 11/28/2006 Qty: 40 Um: Each
Written By : JA 061107
Checked & Approved By :
Comment : Est Rev: A 06-03-21 New Issue JLM
Est Rev: B 06-08-28 As per Rev B JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0750 6061-T6 Round Bar .750"



Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s) 4.25 *
6061-T6 Round Bar .750"
(M6061T6R750)
Batch: 191-130

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492
Dwg Rev: B
Folio Rev: A04

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 29364

Part Number: D3492043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

yl am 06/11/21 x80

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

a.m 06/11/21 (x80)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 07/01/10 (79)

9.0 NAS1611013 O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Qty Part Number Description Batch
1 NAS1611-013 O-RING

*01514 x48 M103500 X32
yl 07/02/13 (32)*

10.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: Hand Finishing
2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: 101223

yl 07/02/13 x32

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

m 07 02 14 (32)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

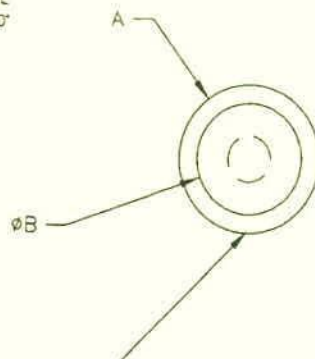
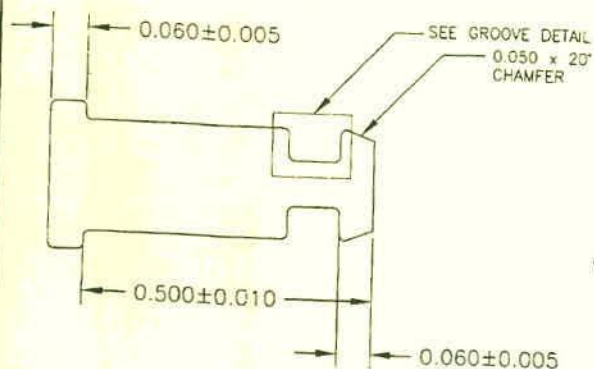
FP 15 yl 07/02/13 x32

13.0 QC21 FINAL INSPECTION/W/O RELEASE

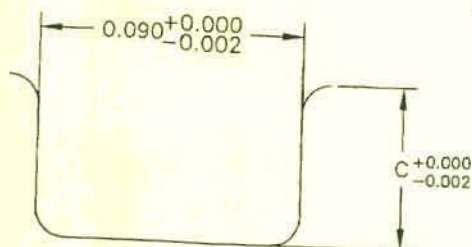


Comment: FINAL INSPECTION/W/O RELEASE

*yl 07 02 14 (32)
u 07 02 14*



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

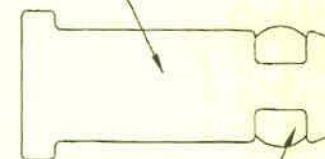
P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500



D3492-1/-3/-5/-7 PLUG NOTES

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED
OF 10 02 99
PER ELM #351

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING



B	06.05.11	ADD -047; UPDATE DIM A, -045
A	06.01.04	NEW ISSUE
DESIGN	BY	
CHECKED	BY	
DATE	06.05.11	
DRAWN BY		
APPROVED	BY	
DRAWING NO.	D3492	REV. B
TITLE	PLUG	SHEET 1 OF 1
SCALE		NTS

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